IN THE SUBSTITUTE SPECIFICATION:

Please cancel paragraphs 024, 025, 026, 027, 033, 036, 037, 039, 040, 042, 043, 045, 046, 047, 048, 049, 050, 051, 052 and 053 of the Substitute Specification. Please replace those cancelled paragraphs with replacement paragraphs, also 024, 025, 026, 027, 033, 036, 037, 039, 040, 042, 043, 045, 046, 047, 048, 049, 050, 051, 052 and 053, all as follows.

[024] In the preferred embodiment shown in Fig. 1 through 4, each roller lock 21 is equipped with four actuators 22, which are arranged in a circular pattern around the axis 19 of the roller 04; 06; 07; 08; 09; 11. These four actuators 22 are preferably distributed, with equal spacing, around the axis 19 of the roller 04; 06; 07; 08; 09; 11 that is adjustable in terms of its contact pressure. The actuators 22 are remotely controllable. In other words, actuators 22 can be activated by the use of a control unit 60 which is ~~not specifically~~ depicted schematically in Fig. 7, and are preferably configured as pneumatic actuators 22. A compressed gas, preferably compressed air, is used as the pressure medium, for example. Possible alternatives to the preferred pneumatic actuators 22 are especially hydraulic actuators 22, which are impinged upon by a fluid, or electromotive actuators 22. As is shown in Fig. 5 and 6 in a schematic representation, each actuator 22, when it has been pressurized with a pressure medium, exerts a radial force Fn1; Fn2; Fn3; Fn4, directed toward the interior of its roller lock 21, on the roller 04; 06; 07; 08; 09; 11 that is connected to the roller lock 21 and which radial force is adjustable in terms of its contact pressure. The actuators 22 are preferably radially supported against or in the frame holder 23 of the roller lock 21, and exert the radial force Fn1; Fn2; Fn3;

Fn4 on the roller 04; 06; 07; 08; 09; 11, which is attached to the roller holder 24 and which radial force is adjustable in terms of its contact pressure. This is accomplished by exerting the surface pressure on the roller holder 24 that is arranged in the frame holder 23 such that the roller holder 24 can be radially displaced. Accordingly, the pressure exerted by the pressure medium in the respective actuator 22 and the radial force Fn1; Fn2; Fn3; Fn4 of that actuator 22 correspond to one another. Radial forces Fn1; Fn2; Fn3; Fn4 exerted simultaneously by the plurality of actuators 22 situated in the same roller lock 21 form an opening angle with one another, which opening angle deviates from 0° and 180°, preferably lying between 45° and 135°, and is, for example, 90°. The contact pressure that is exerted on an adjacent rotational body 12; 13; 14; 16; 17 by a roller 04; 06; 07; 08; 09; 11, which is adjustable in terms of its contact pressure, in a roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 then is a result of a vector sum of the radial forces Fn1; Fn2; Fn3; Fn4 that are exerted simultaneously by the actuators 22 in one roller lock 21, and, if applicable, taking into account a force of weight that is at least partially exerted on the adjacent rotational body 12; 13; 14; 16; 17 by the adjustable roller 04; 06; 07; 08; 09; 11, as a function of its own mass.

[025] With an identifying element "n" in the radial force designator Fn1; Fn2; Fn3; Fn4 a specific roller lock 21 can be designated and therefore identified. Further discussion of the significance of the identifying element "n" will be addressed below. Preferably, each roller lock 21 that is built into the printing machine, and which is a component of an adjustable roller 04; 06; 07; 08; 09; 11, is assigned an identification code that can be

used in the control process as an address with which the roller lock 21 can be clearly identified in the printing machine or at least in a printing couple 01, and which roller lock 21 can thereby be selected in the control process. In the same manner, each actuator 22 that is a part of a roller lock 21, is also assigned an identification code. This identification code insures that each actuator 22 in one of the roller locks 21 that are arranged in the printing machine or in the respective printing couple 01 can be clearly identified, selected, and controlled. Furthermore, as with the above-described identification codes, the pressure chamber 29 that is part of the fixation device of each roller lock 21 is assigned an identification code. Each fixation device for the roller locks 21 that are arranged in the printing machine or in the printing couple 01 can be clearly identified. The respective identification code for each of the roller locks 21, their actuators 22 and their fixation device is preferably machine readable and can be stored in the control unit 60, which control unit 60 is preferably an electronic control unit that processes digital data.

[026] In the preferred embodiment which is shown in Fig. 1 through 4, the identification code for the actuators 22 and the fixation device of each roller lock 21 consists of a series of numerals, with a first numeral designating the relevant roller lock 21 and with a second numeral designating the relevant actuator 22 in the respective roller lock 21 or its fixation device. Thus, each identification code nm, with an identifying element n; m for the roller lock 21, its actuators 22 and its fixation device, designates a clearly specified roller lock 21 in the printing couple 01, a clearly specified actuator 22 in the printing couple 01, and a clearly specified fixation device in the printing couple 01. The

identification code nm thus specifies a roller lock 21 with its first identifying element n, and a specific actuator 22 in this roller lock 21, or its fixation device, with its second identifying element m. For example, the identification code "12" consisting, for example, of a two-digit number, designates with its first numeral the roller lock 21 identified by the number "1", which in the example shown in Fig. 1 through 4 is assigned to the dampening forme roller 04. The second numeral in the numeric sequence, which in this case was selected as the number "2", designates a very specific actuator 22 in the roller lock 21 identified by the number "1". The identification code "15" in this example designates the fixation device of the roller lock 21 that is designated by the number "1". In the example shown in Fig. 1 through 4, the identification code nm relates to numeric sequences comprised of a first identifying element "n" comprising a number between "1" and "6", because six roller locks 21 requiring differentiation are provided, and a second identifying element "m" comprising a number between "1" and "5" for the four actuators 22 for each roller lock 21 and the allocated fixation device. Because each roller lock 21, each of its actuators 22, and each fixation device in the printing couple 01 is assigned an identification code nm, each roller lock 21, each actuator 22 and each fixation device can be clearly identified and addressed. The identification codes nm can each be stored, for example, in the control unit 60 as an individual, unambiguous address, with which each roller lock 21, each actuator 22 and each fixation device can be identified, selected, addressed and controlled by the control unit, separately and independently of other roller locks 21, actuators 22 and fixation devices arranged in the printing couple 01.

[027] When both ends 18 of the same roller 04; 06; 07; 08; 09; 11, that can be adjusted in terms of contact pressure and/or its position, can be changed, and/or when at least one end 18 of two different rollers 04; 06; 07; 08; 09; 11, that can each be adjusted in terms of contact pressure and/or their positions, can be changed, and when both such ends are each seated in a support bearing 21, in other words in a roller lock 21 having a roller mount 39 that is capable of radial travel, with each support bearing 21 having at least one actuator 22 that acts upon the roller 04; 06; 07; 08; 09; 11, the control unit 60 controls at least the actuator 22 of at least the two support bearings 21 supporting the roller ends 18 separately and independently of other support bearings 21 and actuators 22. The control unit 60 accordingly controls at least one actuator 22 in a support bearing 21 separately and independently of an actuator 22 in another support bearing 21. The control unit 60 can also control groups of actuators 22 and support bearings 21 together, particularly if these jointly controlled actuators 22 and support bearings 21 form a functional system, or if, in other words, and based upon their technical function in the printing process, these actuators 22 and support bearings 21 must continuously and necessarily be positioned in a fixed arrangement relative to one another.

[033] In the preferred embodiment of a pneumatic circuit for the actuators 22, as shown in Fig. 7, in all of the roller locks 21 which are arranged in the printing couple 01, are preferably either electrically or electromagnetically activated, controllable devices which are arranged in the pressure conduit 41 that leads from the pressure source, which devices are preferably configured as rapid-reaction proportional valves EP1; EP2; or EP3; EP4, such as, for example, 3/3-way proportional valves EP1; EP2; EP3; EP4.

These valves determine the pressure level 42 that is present at the respective actuators, and wherein, for example, one of the proportional valves EP1; EP2; EP3; EP4 is allocated to each roller lock 21. The control unit 60 activates actuators 22, which are arranged in the roller locks 21, via the proportional valves EP1; EP2; EP3; EP4. Two additional controllable devices are provided in the circuit, which preferably are configured as electrically or as electromagnetically actuatable valves EP5; EP6, such as, for example, as 5/2-way valves, and which are arranged in the pressure conduit 41 on the pathway of the pressure medium from its pressure source to the actuators 22 in a series connection, downstream from one of the proportional valves EP1; EP2; EP3; EP4. These 5/2-way valves allow the selection of whether actuators 22 on "Side I" of the roller 04; 06; 07; 08; 09; 11, that is adjustable in terms of its contact pressure, will be pressurized at the same pressure as "Side II", or at a different pressure. The pressure level 42 can be adjusted by the use of the proportional valves EP1; EP2; EP3; EP4 to any level, such as for example, between 0 bar and 10 bar, and preferably between 0 bar and 6 bar.

[036] In the two operational positions of the controllable device, the pressure level 42 that exists at multiple ones of, or at all actuators 22 in one roller lock 21 is also completely different, so that each of the actuators 22 in one roller lock 21 is pressurized at a different pressure level 42. Actuators 22, which are designated by the same identifying element "m" in different roller locks 21, can have the same pressure level 42, while actuators 22 in the same roller lock 21 having different identifying elements "m" as a rule have different pressure levels 42. The switch between the first operational

position and the second operational position is preferably made abruptly via a switching operation of the controllable device, as initiated by the control unit. Accordingly, the controllable device acts on pressure conduits 41 that lead to all actuators 22 in the same roller lock 21 in the same manner, and can comprise, for example, a flow-check valve having multiple passageways that are independent of one another, or multiple synchronously, or in other words, simultaneously, switched flow-check valves, or a switching position for the proportional valves EP1; EP2; EP3; EP4. Because the adjustment of all of the actuators that are involved in the switch is performed simultaneously, or in other words, is performed synchronously, the adjustment of contact pressure that is exerted on an adjacent rotational body 12; 13; 14; 16; 17 by a roller 04; 06; 07; 08; 09; 11 in a roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 occurs rapidly, or, in other words, occurs within a very short period of time. In this manner, during an adjustment of the setting of the inking unit 02 or the dampening unit 03, especially when the printing couple is running in production, an unstable operating condition, that tends to lead to vibrations, is prevented. If multiple rollers 04; 06; 07; 08; 09; 11 each seated in roller locks 21 are provided, with each roller lock 21 having an identifying element "n", the control unit 60 selects the controllable device that is allocated to each roller lock 21 in each case based upon the identifying element "n".

[037] The printing couple 01 can have a standard configuration with respect to the contact pressure exerted by rollers 04; 06; 07; 08; 09; 11, with that standard configuration comprising a set of values FN11; FN12; FN21; FN22; FN31; FN32; FN41;

FN42; FN51; FN52; FN61; FN62, wherein each such value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 corresponds to a contact pressure exerted by a roller 04; 06; 07; 08; 09; 11 of this printing couple 01 in a roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 on a rotational body 12; 13; 14; 16; 17 that is adjacent to the respective roller 04; 06; 07; 08; 09; 11. The standard configuration can, for example, consist of numerical values, of value pairs or of value sequences which are listed in a table or graphic. The control unit 60 accesses these numerical values, value pairs or value sequences using a program intended for adjusting a desired contact pressure, which program is run in the control unit 60, and which uses these numerical values, value pairs or value sequences to adjust the desired contact pressure.

[039] The values FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of the contact pressures exerted in the roller strips N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62, the values of the radial forces Fn1; Fn2; Fn3; Fn4 allocated to each of these, which are preferably subdivided into value and direction of action, and, if applicable, the mass of the adjustable roller 04; 06; 07; 08; 09; 11 are preferably stored in a memory device in the control unit 60. Also stored in the memory device of the control unit 60 are preferably the value of the gravitational constants for calculating the force of weight from the mass of the adjustable roller 04; 06; 07; 08; 09; 11, and for each roller 04; 06; 07; 08; 09; 11 that is controllable, in terms of its contact pressure, a value for the distance from the center point of the roller 04; 06; 07; 08; 09; 11, which lies on its axis 19, to the center point of the respective adjacent

rotational body 12; 13; 14; 16; 17 with which it is in direct contact. Each value for one of these distances can be subdivided to provide an indication of its absolute value and of its spatial direction.

[040] In a standard configuration, which is based upon the values FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 for the contact pressures that are stored in the memory device of the control unit 60, in the direct contact between rollers 04; 06; 07; 08; 09; 11 that are adjustable, in terms of their contact pressure, and rotational bodies 12; 13; 14; 16; 17, with the two being engaged on one another, a specific degree of flattening of the respective cylindrical circumferential surface of the roller 04; 06; 07; 08; 09; 11, the rotational body 12; 13; 14; 16; 17, or both results. A chord of the flattened area, corresponding to the width of the roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62, extends along the circumference of the roller 04; 06; 07; 08; 09; 11 or of the rotational body 12; 13; 14; 16; 17. The standard configuration generates a degree of flattening that corresponds to a specific target value for the width of each roller strip which is selected N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62, in order to achieve a high quality of the printed product to be produced, using the printing couple 01 under standard operating conditions.

[042] The control unit 60 is equipped with at least one control element and, with, for example, one display device for use in displaying one or more values FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 for the contact pressure that is exerted in a specific roller strip N11; N12; N21; N22; N31; N32; N41;

N42; N51; N52; N61; N62. The reference symbols for the roller strips N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62, which have been chosen here by way of example, can also be used as identification codes for the roller strips N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62, so that each roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 can be clearly identified by its identification code.

[043] By use of the control element of the control unit 60, which control element is configured, for example, as a button, as a keypad, or as a pointer instrument, a specific roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 can be selected, for example, from a list of all roller strips N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 in a printing couple 01 that are provided with an identification code. Alternatively, the identification code of a specific roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 can be input into the control unit 60 via its control element. For each of these roller strips N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62, at least for the standard configuration, a value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62, especially a target value, for the contact pressure exerted in the roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 is stored in the memory device of the control unit 60. During the selection of, or during the input of the identification code for a specific roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 this value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 is displayed, such as, for example, numerically, alphanumerically, in a diagram, or in a pictogram on

the display device, which display device is capable of displaying alphanumeric or graphic symbols.

[045] For the new value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of the contact pressure to be exerted in the selected roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62, the control unit 60 calculates the correct values for the radial forces Fn1; Fn2; Fn3; Fn4 to be exerted in the relevant roller lock 21 and/or for the new pressures to be set in the actuators 22, and stores the calculated values for these radial forces Fn1; Fn2; Fn3; Fn4 and/or for these pressures in its memory device. The control unit 60 also controls the valves V15; V25; V35; V45; V55; V65, the proportional valves EP1; EP2; EP3; EP4 and the valves EP5; EP6. The calculation of the new values FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 and/or the control of the valves V15; V25; V35; V45; V55; V65, the proportional valves EP1; EP2; EP3; EP4 and/or the valves EP5; EP6 is preferably implemented after the control unit 60 has received a specific instruction to do so, which specific instruction can, for example, be input or selected via the control element.

[046] The calculation of the new values FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 for the contact pressures takes into account the fact that these values and the radial forces Fn1; Fn2; Fn3; Fn4, in their original levels, and their new levels, are each to be viewed as a vector quantity. Accordingly, the control unit 60 uses suitable methods for calculating vector quantities. For instance, in addition

to appropriate algebraic calculating methods, other methods, such as, for example, trigonometric calculating methods can also be used to calculate individual components of the respective vectors. In the calculation process, the control unit 60 includes, to the degree necessary, its previously input, essentially unchangeable values, such as, for example, the respective mass of the adjustable rollers 04; 06; 07; 08; 09; 11 and the distance from the center of each roller 04; 06; 07; 08; 09; 11, that is adjustable in terms of its contact pressure, to the center of its respective adjacent rotational body 12; 13; 14; 16; 17. The result of the calculation can be displayed by the display device of the control unit 60, for example in the same manner as the original values FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62.

[047] In order to set the new value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 for the contact pressure that is exerted in a selected roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62, the control unit 60 first uses at least one of the valves V15; V25; V35; V45; V55; V65 to actuate the fixation device of the specific roller lock 21 in which the radial force Fn1; Fn2; Fn3; Fn4 of at least one actuator 22 is to be adjusted to the calculated new value. The adjustable roller 04; 06; 07; 08; 09; 11 that is seated in this roller lock 21 can now be radially displaced. The control unit 60 then actuates at least one of the proportional valves EP1; EP2; EP3; EP4 and/or at least one of the valves EP5; EP6 in order to adjust the radial force Fn1; Fn2; Fn3; Fn4 of at least one actuator 22 in the respective roller lock 21 to the calculated new value. Afterward, the control unit 60 again actuates the at least one valve V15; V25; V35; V45; V55; V65, that was actuated previously, to shift the fixation

device of that roller lock 21, in which the radial force Fn1; Fn2; Fn3; Fn4 of at least one actuator 22 has been adjusted to the calculated new value, to the operational position, in which the roller 04; 06; 07; 08; 09; 11, that is adjustable in terms of its contact pressure and which is seated in this roller lock 21, can no longer be radially displaced. The new value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 for the contact pressure, which is exerted in a selected roller strip, N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 also results in a change in the width of this roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62.

[048] The above-described change in a value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 for the contact pressure exerted in a selected roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 can be implemented for multiple rollers 04; 06; 07; 08; 09; 11, that are adjustable in terms of their contact pressure, either simultaneously or sequentially. For example, the values FN11; FN12; FN21; FN22; FN31; FN32 of all of the contact pressures exerted by the forme rollers 04; 06; 07, in other words the dampening forme roller 04 and the ink forme rollers 06; 07, can be changed at the same time. Alternatively, the value FN21; FN22; FN31; FN32; FN51; FN52; FN61; FN62 of all of the contact pressures which are exerted by the rollers 06; 07; 09; 11 of the inking unit 02, or the values FN11; FN12; FN41; FN42 of all of the contact pressures which are exerted by the rollers 04; 08 of the dampening unit 03, or the values FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of the contact pressures of all of the rollers 04; 06; 07; 08; 09;

11 in the printing couple 01 can be changed at the same time. Thus, groups of simultaneously adjustable values FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 can be formed. With the control unit 60, the values FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of the contact pressures of all of the rollers 04; 06; 07; 08; 09; 11 that are to be adjusted, in terms of their contact pressure, such as, for example, those of an inking unit 02 and/or of a dampening unit 03, can be reset within a time period of less than one minute, and preferably can be reset within a period of a few seconds.

[049] Each value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of the contact pressure exerted by a roller 04; 06; 07; 08; 09; 11, which has been changed once or even multiple times, for example via the control element in the control unit 60, to the value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 that corresponds to the standard configuration, and especially to the target value for the contact pressure which is exerted in the corresponding roller strip, N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62, can be reset.

[050] The control unit 60 is configured, for example, as a component of a control center that is part of the printing machine or that, at least, is a part of the printing couple 01, and is thus allocated to the printing machine or to the printing couple 01. As an alternative or in addition, the control unit 60 can be configured, for example, as a mobile component, such as, for example, as a notebook, which is connected to the controllable

device that is actuated for the purpose of implementing such a change, in other words particularly to the respective proportional valves EP1; EP2; EP3; EP4, to the valves EP5; EP6 and to the valves V15; V25; V35; V45; V55; V65, only when a value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of a contact pressure that is exerted in a roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 is to be changed.

[051] To implement a change in the value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of a contact pressure that is exerted in a roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62, proof of authorization may be required. Accordingly, prior to implementation of the change, for example, a recognizable password must be input into the control unit 60 via its control element.

[052] The change in the value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of a contact pressure that is exerted in a roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 can be implemented during the rotation of the respective roller 04; 06; 07; 08; 09; 11. As long as at least one channel, with a preferably slot-shaped, continuous opening that extends in an axial direction along the forme cylinder 12, and over at least the width of at least one printing forme, and which channel is configured to hold attachment hooks that are bent at the printing formes, is formed on the circumferential surface of the forme cylinder 12 in its axial direction, the change in the value FN11; FN21; FN31 of the contact pressure exerted in

this roller strip N11; N21; N31 can occur when the opening in the channel and the roller strip N11; N21; N31 have no common overlapping surface. This is to insure that during the setting of the new value of the contact pressure exerted in this roller strip N11; N21; N31, the roller 04; 06; 07 will not be pressed into the opening in the channel. Accordingly, the contact pressure, which is exerted in a roller strip N11; N21; N31, is changed by the control unit only at times during which the roller 04; 06; 07 that is to be displaced and/or that is to be adjusted in terms of its contact pressure, is rolling on the closed, customarily solidly configured portion of the circumferential surface of the forme cylinder 12 and/or on the surface of at least one printing forme that is mounted on the forme cylinder 12. During the rollover of the roller over the opening in the channel, the control unit 60 blocks any change in the setting of the contact pressure which is exerted in the roller strip N11; N21; N31.

[053] To verify this condition, a sensor that registers the current angular position of the forme cylinder 12 and/or of the roller 04; 06; 07, such as a torque angle gauge, which transmits a signal corresponding to the current angular position to the control unit 60, can be attached to the forme cylinder and/or to the roller 04; 06; 07. The control unit 60 evaluates the transmitted signal as a release signal which is indicating the permissibility of a change in the setting of a contact pressure that is exerted in the roller strip N11; N21; N31. If the above condition cannot be fulfilled, or if it can be fulfilled only with complications, the forme cylinder 12 and the roller 04; 06; 07 in whose joint roller strip N11; N21; N31 the value FN11; FN21; FN31 of the contact pressure exerted therein is to be changed are placed in rotation, specifically at a speed at which a rollover of the

opening in the channel by the roller 04; 06; 07 during the setting of the new value for its contact pressure exerted in this roller strip N11; N21; N31 will not produce a negative effect. The duration of the rollover is very short, and thus will outweigh the effect of the inertia of the masses involved. Furthermore, the implementation of the change in the value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of a contact pressure exerted in a roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 during the rotation of the respective roller 04; 06; 07; 08; 09; 11 also has the advantage of preventing slip-stick effects. The change in the value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of a contact pressure which is exerted in a roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 is thus implemented during the rotation of the relevant roller 04; 06; 07; 08; 09; 11 and its respective adjacent rotational body 12; 13; 14; 16; 17 at a speed of, for example, at least 3,000 revolutions per hour, and preferably at a speed of at least 5,000 revolutions per hour or more. The implementation of the change in the value FN11; FN12; FN21; FN22; FN31; FN32; FN41; FN42; FN51; FN52; FN61; FN62 of a contact pressure which is exerted in a roller strip N11; N12; N21; N22; N31; N32; N41; N42; N51; N52; N61; N62 can thus also take place when the printing couple 01 is running in production.